

Date: Tuesday, 09/12/2008 9:39:00 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HAT BIN (407)
Job Number : 43953	
Estimate Number : 13676	
P.O. Number :	Part Number : D38351
This Issue : 09/12/2008 S.O. No. :	Drawing Number : D3835-1
Prsht Rev. : NC	Project Number : IN0002
First Issue : // Type : THERMOFORMING	Drawing Revision : PROTOTYPE
Previous Run :	Material : MKYD6185S080P362015
Written By :	Due Date : 16/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.12.09</u>	
Comment : Est. Rev. A. 08.12.03 New Issue DL	

Additional Product

PROTOTYPE
 08.12.03 MLL

Job Number:



UPDATED PL 08.12.22

Seq. #:	Machine Or Operation:	Description :	PER TEST 08.12.16
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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MATERIAL CERTIFICATION
 REQ'D UPON DELIVERY



Comment: Qty.: 11.9438 sf(s)/Unit Total : 11.9438 sf(s)
 6185 Kydex .080"

M 109703 DL 08.12.10

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

DL 08.12.10

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

DL 08.12.10

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3835-1 and folio (FTA 407 Hatbin)

Dwg. Rev. PROTOTYPE
 Folio Rev. A

DL 08.12.10

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

DL 08.12.10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: JA Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.12.10	4	PARTS FORMED TOO THIN. X.8. 2	<i>[Signature]</i>	Scrap and replace 8 Hunt pins. scrapped. change to R+D. project 00251A.	DL 08.12.15	<i>[Signature]</i> 08.12.16	<i>[Signature]</i> 12/5/16	<i>[Signature]</i> 12/5/16

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN (407)

Job Number: 43953

Part Number: D38351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



BB 08/12/12



X1

Comment: SECOND CHECK

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/12/12

X1

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 08/12/12

X1

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PH 08.12.12

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

NOT FOR STOCK 08.12.22

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.15 Per type

with deviation
per FAI ATTACHED

Job Completion



08.12.24

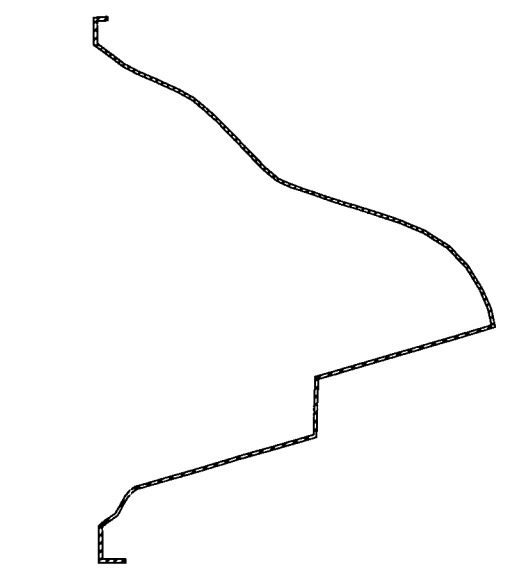
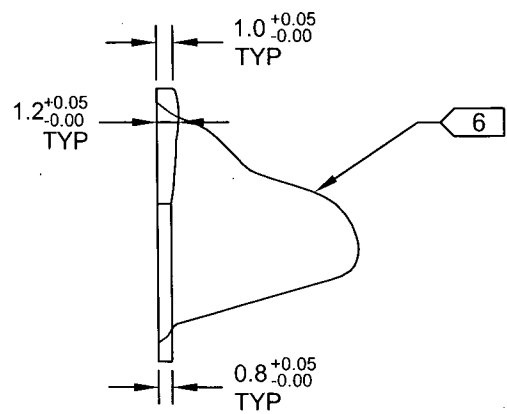
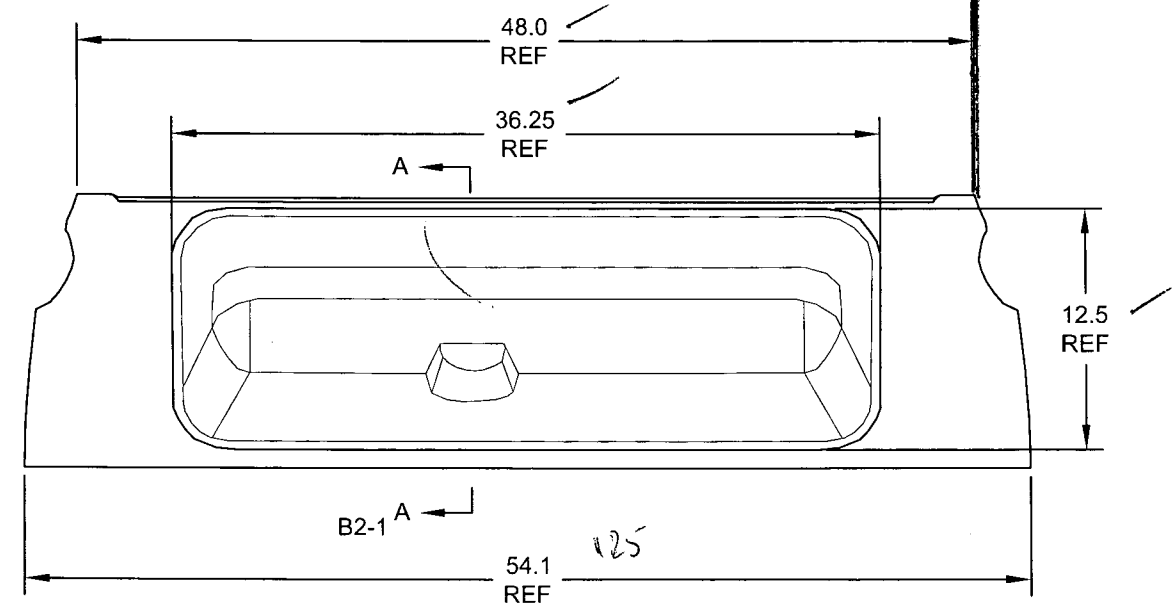
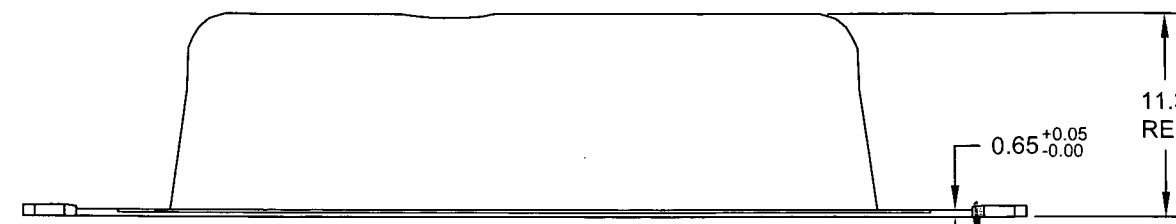
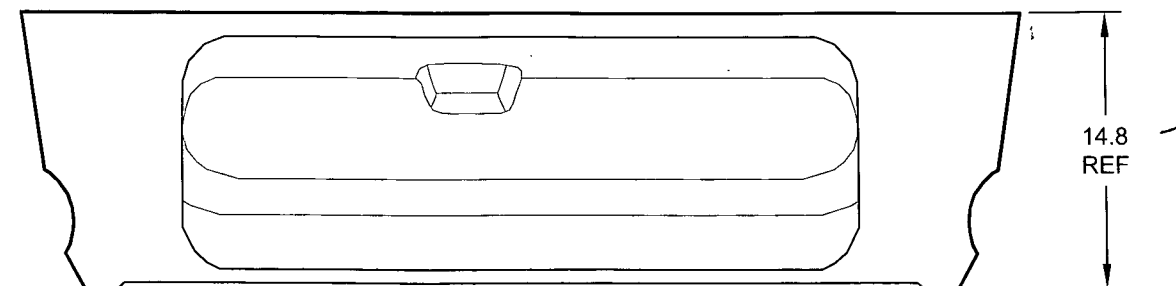
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A B7-1
SCALE 2X

D3835-1 HAT BIN

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.03 PEA

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYDEX6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3835-1" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 4.0 lbs - xxx
 - 8) TOOLING: THERMOFORM PER MOLD DT9449 PER DART QSI 022. TRIM PER MOLD

A	NEW ISSUE	PH	08.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3835	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN	NTS
DATE	08.10.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART AEROSPACE LTD		Work Order: 43953
Description: 407 Hat Bin / Prototype		Part Number: D3835-1
Inspection Dwg: D3835 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype




THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	N/A			
Shape Definition	/			
Texture Retention	/			
Material imperfections such as bumps, cracks, voids, scratching	/			Thin in the corners... Also minor bubbles on the G.8 flange.

Measured by: 	Date: 08.12.12
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.8 (Ref)	± 0.100	14.8125	/			
11.3 (Ref)	" "	11.3	/			
0.65	$\pm 0.05 / - 0.0$	0.7	/			
12.5 (Ref)	± 0.100	12.5	/			
54.1 (Ref)	± 0.100	54.125	/			
48.0 (Ref)	± 0.100	48.0	/			
36.25 (Ref)	± 0.030	36.25	/			
1.2	$\pm 0.05 / - 0.0$	1.26	#	✓		gets trimmed by customer
1.0	$\pm 0.05 / - 0.0$	1.8	#	✓		gets trimmed by customer
0.8	$\pm 0.05 / - 0.0$	0.9 / 0.87	/			"

Measured by: 	Date: 08.12.12
Audited by: 	Date: 08.12.12
Prototype Approval: 	Date: 08.12.12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Date: 8/10/24

Batch No: M109703

Supplier: SABIC

Dart P/O: 7280

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection ns10127 N/A ☐
 Work Order N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

Location/Admin:

Location

سابك
sabic

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

54 804287

084287

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

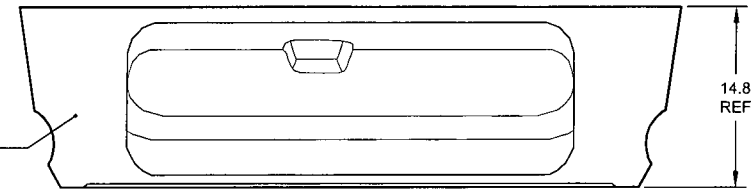
AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

8 7 6 5 4 3 2 1

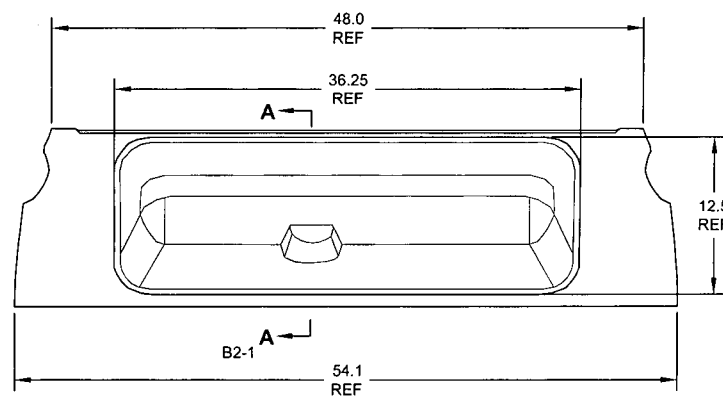
MIN FLANGE
THICKNESS
0.050



14.8
REF



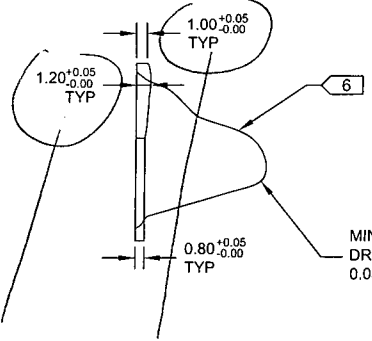
11.3
REF



D3835-1 HAT BIN
(BELL 407)

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.22 *PH*
REVISED FROM 08.12.08
DWG TO INCLUDE DIMENSION
UPDATE PER FAI SHEET

SECTION A-A
SCALE 2X



MIN THICKNESS IN
DRAWN PORTION IS
0.030

DIMS
1.2 are
1.0 kept

1.26
1.27
ACCEPTABLE
FOR TEST
PH 08.12.16

- NOTES:**
- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3835-1" USING VIBRATING STYLUS
 - 7) WEIGHT: 3.3 lbs
 - 8) TOOLING: THERMOFORM PER MOLD DT9449 PER DART QSI 022. TRIM PER MOLD

REV.	NEW ISSUE	DESCRIPTION	PH	08.10.27
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.10.27			

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3835	SHEET 1 OF 1
TITLE	HAT BIN (BELL 407)	SCALE
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